

Work Order ID 84573

May-16-12 1:40:58 PM

\*84573\*

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4485-1

Revision ID:

Item Name: Lower Closeout Panel

Start Date: 16/05/2012 Start Qty: 5.00

Required Date: 25/05/2012 Req'd Qty: 5.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: *PLW*

QC:

Date: 12/05/12 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4485

PB1

*Rev B*

100

\*100\*

Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg  
Dwg Rev: *PB1*  
Prog Rev: *PB1*  
2-Deburr if necessary

0.00

0.00

5

0

*Jm*  
12-5-31

FLOW CNC Waterjet

6061 . C43

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

5

0

*Jm*  
12-5-31

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

0.00 - msp a fees to PB1

0.00

Memo

*Doing only*  
*12/10/13*

(X)

POSITIVE  
RECALL

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____				Rework <input type="checkbox"/>		Skid-tube <input type="checkbox"/>		Crosstube <input type="checkbox"/>		Water Jet <input type="checkbox"/>		Engineering <input checked="" type="checkbox"/>	
NCR No. _____				Scrap <input checked="" type="checkbox"/>		Machining <input type="checkbox"/>		Small Fab <input type="checkbox"/>		Prod. Eng. Coord. <input type="checkbox"/>		Quality <input type="checkbox"/>	
				Use-as-is <input type="checkbox"/>		Thermoforming <input type="checkbox"/>		Finishing <input type="checkbox"/>		Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>	
				Work Order Update <input type="checkbox"/>		Large Fab <input type="checkbox"/>		Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input checked="" type="checkbox"/>	12/12/06	# 100		Parts do not match the current drawing Revision	DAS 16 8-03 ASZ042 12/12/06	SCRAP + Dash Qty 4	[Signature] 12-12-06	DAS 16 8-03 12/12/06	DAS 16 8-03 ASZ042 12/12/06
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY				
Landing Gear		General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input checked="" type="checkbox"/> Other	
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	Drawing change from Prelim to Release	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions		



# Work Order ID 84573

**\*84573\***

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May-16-12 1:40:58 PM

Item ID: D4485-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lower Closeout Panel

Start Date: 16/05/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

121

**\*121\***

Small Fab

Small Fab

Memo

COUNTERSINK AS PER DWG

0.00

0.00

5x

12/06/05

122

**\*122\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

inspector P131  
Dg only  
8/12/05

(8)

POSITIVE  
RECALL

125

**\*125\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

5- 2/6 12-6-5  
5- 2/6 12-9-17

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

# Work Order ID 84573

May-16-12 1:40:58 PM

**\*84573\***

Page 3

Item ID: D4485-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Lower Closeout Panel

Stop **\*NS2\***

Start Date: 16/05/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

126

QC3- Inspect Part Finish

0.00

**\*126\***

QC

Memo

0.00

Quality Control

**\*127**

128. QC 14 Prime Greg per QSI 5  
12-07-25 (4)

130

Identify as per dwg & Stock Location:

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

LD3342

POSITIVE RECALL

EFFECTIVE

AUTH

PLEASED

DATE

12/12/10

MF  
PG  
12-7/12



NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

May-16-12 1:41:03 PM

Page 1

T

Work Order ID: 84573

\*84573\*

Parent Item: D4485-1

\*D4485-1\*

Parent Item Name: Lower Closeout Panel

Start Date: 16/05/2012

Required Date: 25/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 11.12.13 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	230.8922		4.5			
*M6061T6S 063*									**				
6061-T6 .063 Sheet													

Location	Loc Qty	Loc Code
MAT021	230.8922000	
113608	0	
116308	6.01556842	
117285	67.544	
119331	44.2	
119802	18.94	
120218	19.5	
120866	66.9426316	
121578	7.75	

121578

JM  
12-5-3

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



DART AEROSPACE LTD		Work Order: 84573
Description: Lower Chassis Panel		Part Number: D4485-1
Inspection Dwg: D4485-1	Rev: PB1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.181	+0.005 -0.001	0.183	✓		V	HB-02
6.64	± 0.030	6.696	✓		V	HB-02
9.01	± 0.030	9.014	✓		V	Prod-W-02
8.29	± 0.030	8.297	✓		V	Prod-W-02
1.25	± 0.030	1.239	✓		V	HB-02
1.92	± 0.030	1.907	✓		V	HB-02
2.35	± 0.030	2.348	✓		V	HB-02
0.25	± 0.030	0.253	✓		V	HB-02
3.40	± 0.030	3.401	✓		V	HB-02
1.87	± 0.030	1.87	✓		V	HB-02
0.37	± 0.030	0.376	✓		V	HB-02
1.75	± 0.030	1.744	✓		V	HB-02
13.375	± 0.070	13.375	✓		MT	HB-01
4.809	± 0.010	4.809	✓		V	HB-02
27.350	± 0.00	27.350	✓		MT	HB-01
0.063	± 0.010	0.062	✓		V	HB-02
Grain Direction		✓				

Measured by: Jm	Audited by: E	Prototype Approval:	N/A
Date: 12-5-31	Date: 12/6/31	Date:	N/A
Rev A	Date	Change	Revised by
		New Issue	KJ/JLM
			Approved

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY										
Landing Gear			General							
<input type="checkbox"/> Bending	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Cracks	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Wave/Twist in Tube
<input type="checkbox"/> Bend	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Burrs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Countersink	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Drawing	<input type="checkbox"/> Finish	<input type="checkbox"/> Folio
<input type="checkbox"/> Grain	<input type="checkbox"/> Hardware	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Misread	<input type="checkbox"/> Offset	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ovalized	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> Temperature/Cure	<input type="checkbox"/> Weld	<input type="checkbox"/> Wrong Stock Pulled
							<input type="checkbox"/> Other			



PRELIMINARY B1  
12.05.09 (AJS)

STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHOUT NOTICE  
WORK ORDER

8457 S MLJ  
12/05/10

Ø0.181 THRU  
Ø0.331 X 100° CSK  
TYP

GRAIN  
DIRECTION

**D4485-1 LOWER CLOSEOUT PANEL**

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER AMS 4025 OR AMS 4027 OR ASTM B209  
REF M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.49 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING "D4485-1-REVPB1.DXF"

PB1	GENERAL REVISION SEE REV. A FOR DETAILS:		AJS	12.05.09
A	NEW ISSUE		AJS	12.03.05
REV.	DESCRIPTION		RY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. PB1	
MFG. APPR		D4485	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		LOWER CLOSEOUT PANEL	NTS	
DATE	12.05.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATIONS TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD		

NCR: Yes / No

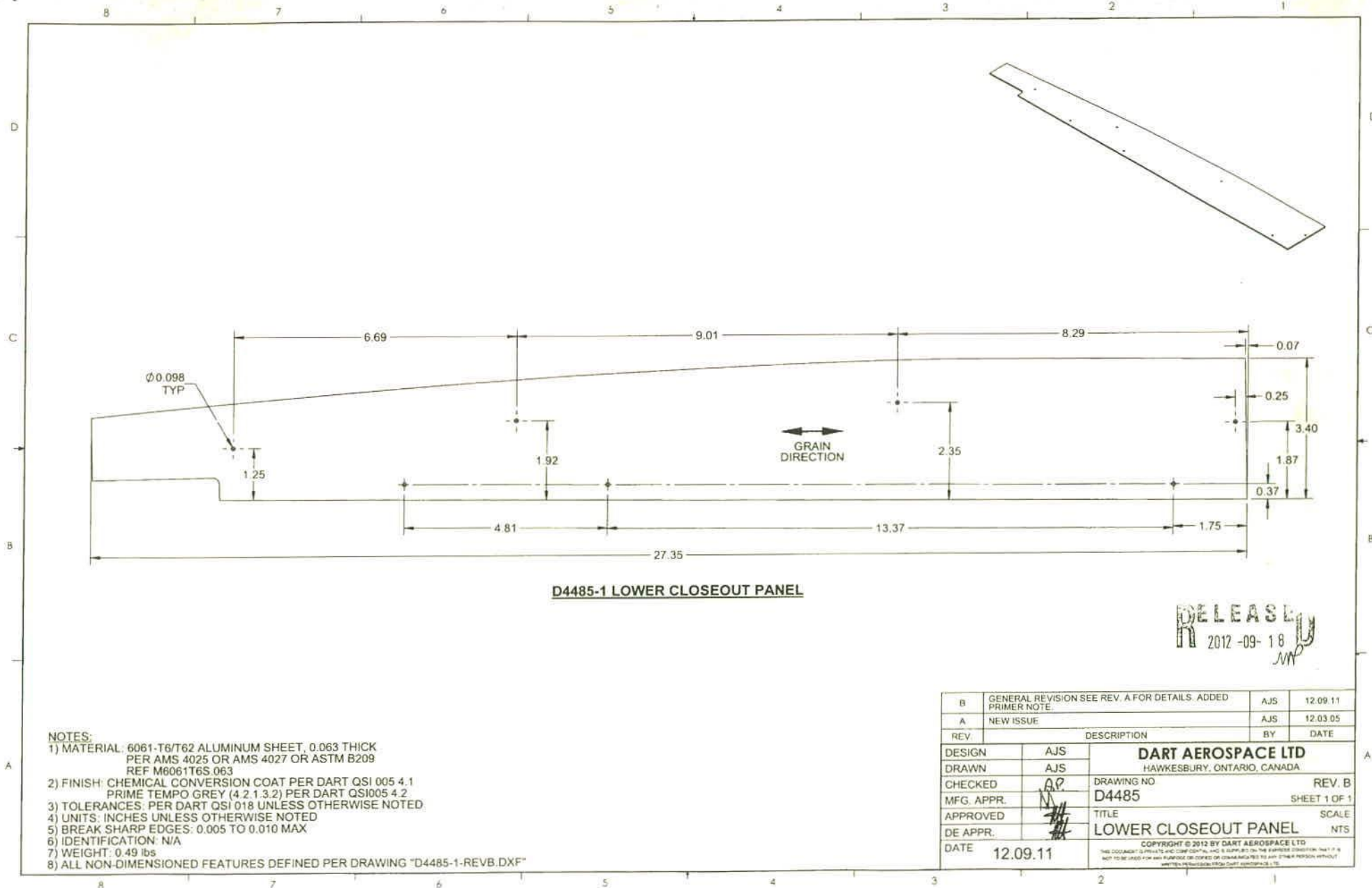
**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		









# Receiving Report

Date: 12/4/20  
 Supplier: MAGNA

Batch No: M121578  
 Dart P/O: 16840

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☒ No ☐ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☒  
 QC6 Inspection 5 ☒ N/A ☐  
 Work Order 105761

Discrepancies						Comments
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	

Initials of receiver (if shipment OK) Level 12 [Signature]

Location  

Production/Admin: 12/4/20  
 Date [Signature]  
 Received/Costing [Signature]  
 Initial [Signature]





Monday, April 30, 2012 12:39:13 PM

Monday, April 30, 2012 12:59:15 PM

All Vendors PO ID PO16840 Receipt Dates from 4/30/2012 to 4/30/2012 All Line Item Types  
All Rec Employees All Currencies

All Vendors PO ID PO16840 Receipt Dates from 1/1/2010 to 12/31/2010  
All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty  (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (rO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless		4/30/2012	4/30/2012	256.0000	\$2.33	0.0000	0	\$597.33
PO16840	I		M6061T6S.063 sf		256.0000	DESJ02		\$597.33	0.0000	0	
CAD	No		6061-T6 .063 Sheet sf								
			121578						Total Received Quantity:		256.0000

Total Received Quantity:	256.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	\$597.32
Total Balance Due Quantity:	0.0000





# Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



\*I058581\*

## PACKING LIST

Page 1 of 1

I058581

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

SPECIAL INSTRUCTIONS

\*\*\*\*STOCK\*\*\*\*

Contact: CHANTAL

Ship Terms: PREPAID

MTR:C

Contact: CHANTAL		Ship Terms: PREPAID		MIME		
Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		CHRISTINA ANTONIOU	(613) 632-5200	(613) 632-1053	PO 16840	
Sales Order	Terms	Ship Via		Date Ordered	Date Required	Date Shipped
W065201	NET 30 DAYS	NIR:R-557065-1		04/27/12	04/30/12	04/30/12
				Bundle #	Heat #	Shipped

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
8		PC	ALUMINUM SHEET ASH 6061 T6 .063" x 48" x 96" 232 LB 8 PC MILL TEST + CDEC REQUIS AVEC LIVRAISON PER ASTM B209 OR QQA 250/11 OR AMS 4025	L052018	112421	8 8
Skids: 1						Approx Weight: 232 LB

Received by: \_\_\_\_\_

Date: \_\_\_\_\_

Signature: \_\_\_\_\_





ZHENGZHOU MINGTAI INDUSTRY CO., LTD  
CHANGCHUN ROAD NO.6, HIGH AND NEW TECHNOLOGY ZONE,  
ZHENGZHOU HENAN CHINA  
TEL:+86-371-67898715 FAX:86-371-67898612

### MILL TEST CERTIFICATE

TO:

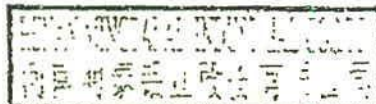
INVOICE NO.: ZOTO110401  
CONTRACT NO: NO1709/1704  
LOADING PORT: QINGDAO, CHINA  
DESTINATION: TORONTO, CANADA  
SHIPPING MARKS: N/M  
DATE: MAY, 2, 2011

#### DESCRIPTION OF GOODS:

ALUMINUM SHEET 5052 H32 CERTIFIED  
TO ALL AA, ASTM B209, AMS/QQA 250/8, AMS 4016L SPECS.  
ALUMINUM TREAD PLATE 3003 H22 CERTIFIED TO ALL AA,  
ASTM B632/B632M.  
ALUMINUM SHEET 6061 T6 CERTIFIED  
TO ASTM B209 (AMS 4027) AND AA SPECS.  
CIF TORONTO, REF: NO1709/1704

CHEMICAL COMPOSITION											
Heat No.	Alloy	Si	Fe	Cu	Mn	Mg	Zn	Ti	Cr	Others	Al
110724B	3003	0.322	0.549	0.054	1.097	0.036	0.042	0.029	< 0.005	0.15	REMAINDER
112421	6061	0.558	0.354	0.233	0.045	1.008	0.012	0.029	0.212	0.15	REMAINDER
112422	6061	0.638	0.383	0.276	0.082	1.027	0.041	0.023	0.229	0.15	REMAINDER
112423	6061	0.630	0.353	0.277	0.076	1.006	0.032	0.021	0.218	0.15	REMAINDER
112424	6061	0.580	0.339	0.269	0.059	1.068	0.022	0.024	0.188	0.15	REMAINDER
112425	6061	0.602	0.358	0.249	0.021	1.008	0.028	0.021	0.214	0.15	REMAINDER
112494	5052	0.133	0.303	0.020	0.070	2.438	0.013	0.018	0.225	0.15	REMAINDER
112639B	3003	0.282	0.504	0.055	1.057	0.025	0.045	0.031	< 0.005	0.15	REMAINDER
MECHANICAL PROPERTY											
Heat No.	Alloy	Temper	Specs(in)	Tensile strength (Mpa/ ksi)		Elongn %					
110724B	3003	H22	0.125*60*120	149		22		20			
112421	6061	T6	0.063*48*96	346		50		10			
112422	6061	T6	0.063*48*120	335		49		11			
112423	6061	T6	0.125*48*120/9	322		47		14			
112424	6061	T6	0.125*48*120/144/96	338		49		12			
112425	6061	T6	0.188*48*96	342		50		11			
112494	5052	H32	0.1*48*120/9	229		33		12			
112639B	3003	H22	0.125*60*120/144	147		21		22			

PRODUCER: ZHENGZHOU MINGTAI INDUSTRY CO., LTD



P13315

032536

S 126101





**MAGNA INOXYDABLE  
INC.**

5775 RUE KIERAN  
ST-LAURENT, QUEBEC  
H4S 0A3 (514) 339-1211, 1-800-363-6646

**CERTIFICAT DE CONFORMITE  
CERTIFICATE OF CONFORMANCE**

**DATE:** April 27, 2012

**COMPAGNIE / DART AEROSPACE  
COMPANY:  
ATTENTION:**

**VOTRE/YOUR #: PO 16840**

**DATE DE LA COMMANDE / 04/27/2012  
ORDER DATE:**

**NOTRE / OUR #: I058581**

<u>DESCRIPTION</u>		<u>QUANTITE/QUANTITY</u>	<u>SPECIFICATIONS</u>
<b>TYPE:</b>	6061-T6	8 PCS	ASTM B209
<b>SIZE:</b>	.063" X 48" X 96"		
<b>HEAT #:</b>	112421		

Magna Stainless certifie que le matériel décrit ci-dessus, s'accorde aux dessins ou aux spécifications demandées sur le bon de commande et qui sont en vigueur à la date où la commande est acceptée.  
Magna Stainless certifies that the material described above is in accordance with the drawing or specifications called for on said order that is current on the date order was accepted.

**MAGNA  
MTR #: L052018**

Signed: Benny M. [Signature]







Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO16840

Purchase Order Date 4/27/12

PO Print Date 4/27/12

Page Number 1 of 1

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA



Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6S.063 024	6061-T6 .063 Sheet	4/30/12 Yes	256.00 sf	Yours ppd 4/27/12	\$2.3125	\$592.00

Special Inst: MATERIAL; 6061-T6/T62 ALUMINUM  
SHEET  
AS PER QQ-A-250/11 OR AMS-QQ-A-  
250/11 OR AMS 4025  
OR AMS 4027 OR ASTM B209

PO Total: \$592.00

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 4/27/12

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable





